

Date: Tuesday, 11/29/2005 2:55:46 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP	
Job Number	: 25015		Part Number	: D2438	
Estimate Number	: 10267		Drawing Number	: D2438 REV. C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/29/2005 S.O. No. : N/A		Drawing Revision	: C	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/18/2005	
Previous Run	: 23818		Qty:	197 200 Um: Each	
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE COMMENT BELOW				
Comment	: Est: E 05.06.28 Bending removed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: 2000000183 Laser cut as per Dwg D2438 Material release note is required	
2.0	D2438B	Clamp
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) CLAMP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2438 (6.786" center to center)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr any rough edges	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25015

Part Number: D2438

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/01/2005

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 178

11/26/2005 197

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/2005

197

06/01/2005

197

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	4	OUR JOB NO	J0136343	SHIPPING MEMO	0327631
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
	200 PCS	PO00000183	D2438	C	CLAMP
MATERIAL		SUPPLIED BY			MAT. REL. NO.
S.S.T 304		SAMUEL SPECIALTY/ AK STEEL			7341615 ATT'D

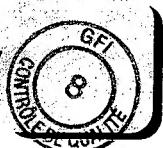
	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 JANUARY 2006

G.F.I. Q.C. REP.

Salter



J. 01-05

**LES ÉTAUX
SPÉCIALISÉS
SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100.

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 1 AOÛT 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0066654 **# de commande SSMQ:** 843000
Customer's order #: SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	.060" X 48" X 96"	304 2B		7341615

Bien à vous,
Yours truly,

José Raymond

Commis à l'administration.
Administration Clerk.

J. 01.05





AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page 1

Load No. 7288793
SRN No. 7288793

C U S T O M E R	SAMUEL & FILS & CIE LTÉE (S) PUR DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7S1N-5	S H X P T O	SAMUEL & FILS (QUEBEC) LTÉE 2225 FRANCIS HUGHES LAVAL, CN H7S1N-5	MILL ORDER NO. 252502-0523	PROCESSOR ORDER NO. C97428-1
				BUYERS ORDER NO. C97428-1	PART NO.

COIL ID	HEAT	PARENT COIL ID	WEIGHT	ENGLISH UNITS		PRODUCT SIZE	METRIC UNITS	
503431-05BA	7341615	0503431-05B	13,140 LBS. 5,960 KG.	.0590	NOM	48.0000	X	COIL
503431-05BB	7341615	0503431-05B	13,050 LBS. 5,919 KG.	.0590	NOM	48.0000	X	COIL
503431-05BC	7341615	0503431-05B	13,130 LBS. 5,956 KG.	.0590	NOM	48.0000	X	COIL

L-Lodic Analysis of Heat		P-Product Analysis of Parent Coil		CHEMICAL ANALYSIS					
ID	C	MN	P	S	SI	CR	NI	MO	N
L 7341615	.052	1.385	.032	.0011	.342	18.18	8.10	.35	.0390
									.37

SHIPPING DATE: 02/16/2005

REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE
MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL.
MATERIAL FREE OF RADIOACTIVE ISOTOPES

PRODUCT DESCRIPTION

CR SHP TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8
* ASTM A 480 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME
SA-240 SECTION II PART A (2001 ED. 2002 ADDENDA) EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * ASME SA-480 SECTION II
PART A (2001 ED) EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * AST
M A 262 -01 PRACTICE E * ASTM A 666 -00 EX 6.1.9 ELONG WILL BE DETERMINED BY ASTM E 8, EX 7.1 TEST SPECIMENS WILL BE SELECTED IN
THE TRANSVERSE TEST DIRECTION IN ALL CASES

PARENT COIL ID	POS (P/T)	DIR (L, T, B)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS TALL	ROCKWELL HARDNESS FRONT			
0503431-05B	T	T	A.S.T.M	58.2	94.7	47.1	B 85.3	B 85.8			

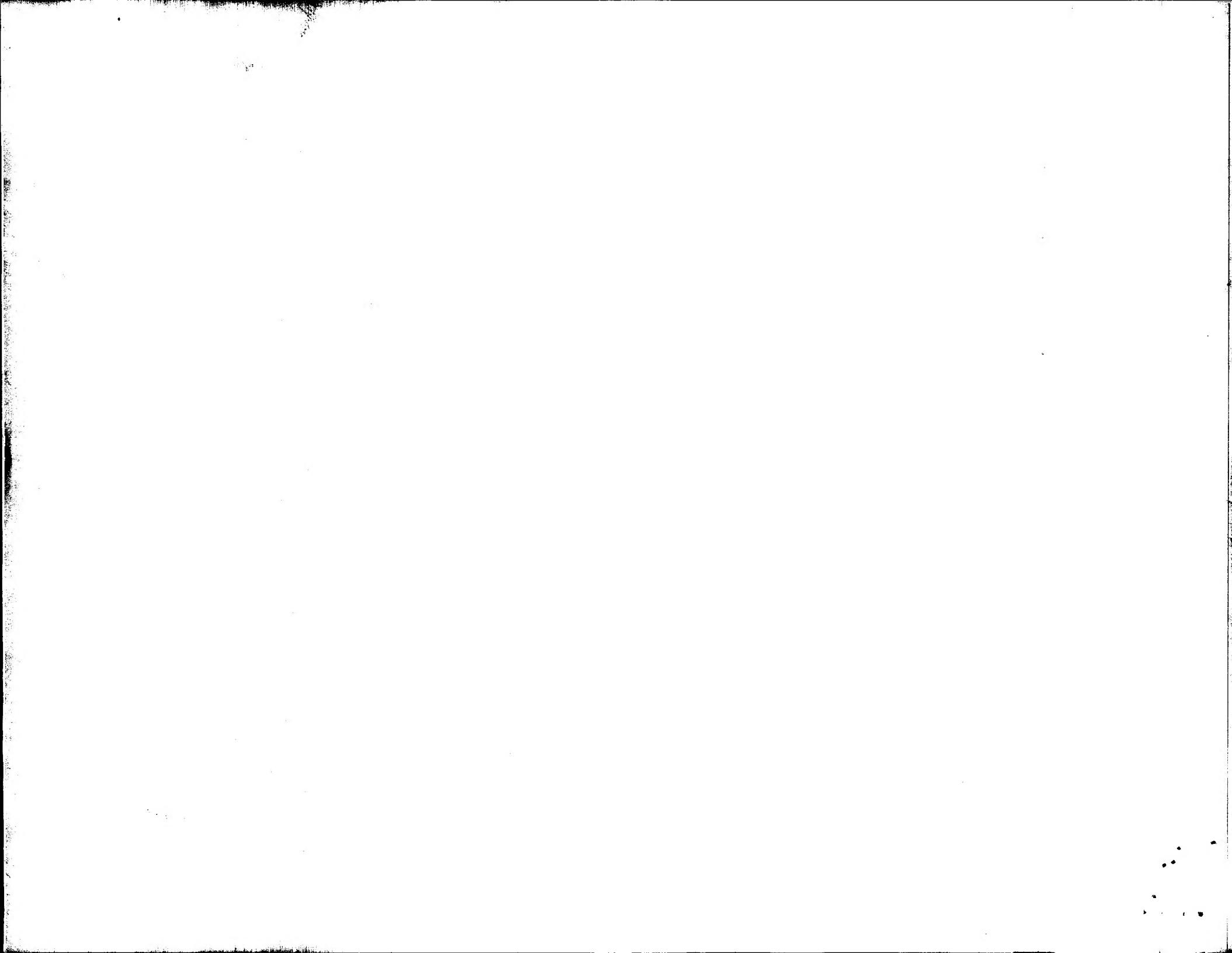
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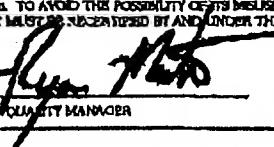
2/17/2005 06:45
FAX: AK Steel RightFax
ID: SAMUEL ET FILS
PAGES: 001 R-22%

FEU-17-2005 06:45

FAX: AK Steel RightFax

PAGES: 001 R-22%



		AK Steel Corporation Metallurgical Test Report Rockport Works Rockport, IN 47635					Page 2				
							Load No. 7288793 SRN No. 7288793				
C O M M I C H U S T O R E	SAMUEL & FILS & CIE LTEE (S) PUR DEPT' 2225 FRANCIS HUGHES LAVAL, CN H7S1N-5			S H I P P Y O	MILL ORDER NO.		PROCESSOR ORDER NO.				
					25292-0523		C97428-1				
			BUYERS ORDER NO.		PART NO.						
			C97428-1								
PARENT COIL ID		POS (W/T) (L, T, D)	DIR A.S.T.M.	COND PRACTICE	ASTM A 262 PRACTICE E	BEND 180 IT					
6583431-05B		T		A.S.T.M.	PASS	OK					
THIS CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION. ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED											
THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK STEEL CORPORATION. TO AVOID THE POSSIBILITY OF ITS BEING ON DELIVERY OF THIS REPORT TO A THIRD PARTY IT MUST BE RECEIVED BY AND UNDER THE NAME OF SUCH CONSIGNEE.											
AK Steel Corporation		MWG00049 3/19			SIGNED	 Quality Manager		DATE 02/17/2005 TIME 09:23 AM			